

*** QUALITY ASSURANCE PROVISIONS**

C-321: SPECIFICATIONS:

NSN: 9G 1615-00-789-8779 P/N:(78286) SS 4062-2

NOMENCLATURE: Valve, Damper Piston

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) SS 4062-2 REV. "2" and all details and specifications referenced therein.

I. QUALITY/INSPECTION REQUIREMENTS

- A. MIL-I-45208 applies:**
- B. First Article Testing applies:**
- C. Production Lot Testing applies:**
- D. Mandatory Inspection applies:**

II. SUPPLEMENTAL REQUIREMENTS

- A. Additionally, para. 3.1, 3.5, 5.1, 5.2, 6.1, 6.2 of MIL-Q-9858 apply.**
- B. The contractor shall include on the detailed process operation sheets developed, a tracking method that is traceable to the contract, all in-house manufacturing processes, and the identity of all manufacturing sources performing process/operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of FIRST ARTICLE OR PRODUCTION LOT TESTING without the approval from the Engineering Support Activity (ESA) via the P.C.O..**
- C. The inspection method sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, castings, or forgings. The tracking method used on the inspection/method sheets shall be traceable to the contract. In addition, the contractor is responsible for providing completed inspection method sheets showing the actual dimensions taken of all critical characteristics.**
- D. Markings should be I/A/W MIL-STD-130 REV . "H" para. 5.3.3(a),(b),(c),(g). Method and location shall be I/A/W the drawing.**
- E. If TEK Precision (65780) is the successful offeror a site survey shall be required.**

III. MANDATORY INSPECTION REQUIREMENTS:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

A. LEVEL OF INSPECTION (L.O.I.)

- 1) Critical Characteristics: 100% inspection applies
- 2) Major and Minor Characteristics: L.O.I. shall be I/A/W a sampling plan acceptable to the Q.A.R..

B. CRITICAL CHARACTERISTICS FOR:

Sikorsky Aircraft P/N: (78286) SS 4062-2

- 1) .451
.450 DIA.
- 2) .200 DIA Concentric with .451 DIA.
.185 within .002 T.I.R. .450
- 3) Angle "A" = 46 +/- 10'

C. MAJOR AND MINOR CHARACTERISTICS:

- 1) Shall be defined by the contractor subject to Q.A.R. concurrence, unless defined on applicable drawings and associated specifications.

IV. THE BELOW LISTED DRAWING APPLY AND ARE BEING FURNISHED:

(78286) SS 4062-2 REV "2"

- V. Unless expressly provided for elsewhere in this clause, equipment such as **FIXTURES, JIGS, DIES, PATTERNS, TEMPLATES, MYLARS, SPECIAL TOOLING, TEST EQUIPMENT**, or any other manufacturing aid required for the manufacture and/or testing of the subject item will not be provided by the government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

I-961 FIRST ARTICLE TEST REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

The tests to be performed under the contract approval clause of the contract are:

- A. Dimensional Check 100%**
- B. Form/Fit**
- C. Compliance with drawing, (78286) SS 4062-2 REV." 2 ", and associated drawings, latest revisions, and specifications referenced therein.**
- D. Review documentation as provided under DD 1423 requirements.**

In addition to the above tests, the First Articles are to be delivered hereunder shall also be subjected to those tests which will demonstrate that the articles comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Samples during testing.

II. Samples to be submitted for testing: Quantity: Two (2)

- A. Estimated cost: TBD**
- B. Waiver of First Article Testing Requirements May be Granted for (78286) Sikorsky Aircraft and (65780) TEK Precision Co. LTD.**

III. Testing shall be performed at the Government Designated facility listed below

**NADEP Cherry Point
F.A.T. Control Center
P.O.C. Betty Lupton, Code: 6.3.674
NAS Cherry Point 28533**

IV. Special Instructions:

A. Samples may be considered as production items under the contract provided that the samples can be refurbished to ready for issue (**RFI**) condition and provide the samples have inspection approval of the cognizant **Q.A.R.** . Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

B. Samples will be returned to the contractor, if not destroyed in testing.

C. Samples are to be unpainted per drawing. Corrosive areas are to be coated with a light preservative.

D. Estimated Production Lead-time Schedule:

1. Submission of the First Article samples by the contractor 150 days.
2. Analysis of report and notification to contractor 45 days.
3. Production delivery after First Article acceptance 150 days.
4. Total accumulated calendar days 345 days

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Samples, the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the P.C.O.. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

Upon shipment of First Article Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the designated test facility. The envelopes shall be clearly marked. "**DO NOT OPEN IN MAILROOM**".

Within 105 days after receipt of the samples, the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to the P.C.O..

C-330 PRODUCTION LOT TESTING REQUIREMENTS

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

I. Production Lot Test Sampling Requirements:

- A.** The cognizant CAO/QAR shall select two (2) items at random from the first production lot produced. In addition the QAR shall select one (1) item at random from each successive lot or portion thereof.
- B.** Production Lot Testing to be completed during production after First Article approval.
- C.** Samples are to be unpainted. Corrosive areas are to be coated with a light preservative.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

- A.** Compliance with drawing, (78286) SS 4062-2 REV. " 2 " and associated drawings, latest revisions, and specifications referenced therein.
- B.** Form/Fit
- C.** Dimensional Check 100%
- E.** Review of documentation as provided under CDRL, DD1423

In addition to the above tests, the Production Lot Samples to be delivered hereunder shall also be subjected to those tests which will demonstrate that the samples comply with contract requirements.

III. Testing Location, Cost and Estimated Lead-time:

- A.** Ship samples/Data to NADEP, Cherry Point, POC: Betty Lupton, Code: 6.3.674
- B.** Shipping container marking: **NON RFI**
- C.** Estimated Cost for Inspection/Test is **TBD.**
- D.** Estimated Lead-time for Inspection/Test is **TBD.**

Within fifteen days of completion of Production Lot Testing, the NAVAVNDEPOT, Cherry Point, shall prepare and submit two copies of the test report with conclusions and recommendations to the contracting officer.

IV. Shipment and Distribution of Samples:

- A. Fourteen (14) days prior to shipment of production lot samples, the contractor shall notify the designated test facility, in writing, of the anticipated shipping date, with an information copy to the P.C.O., . The contractor shall also arrange for preliminary inspection of the test samples by the CAO/QAR.
- B. Upon shipment of Production Lot Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR'S signature and indication of preliminary inspection, shall be forwarded to the P.C.O.. and to the designated test facility. The envelope shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.
- C. Samples may be considered as production items under the contract provided the samples can be refurbished to Ready For Issue (R.F.I.) condition and provided the samples have inspection approval of the cognizant CAO/QAR. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.
- E. Samples will be returned to the contractor.
- I. The designated test facility and the contracting officer shall be notified as to all shipping data applicable to the samples, such as bill of lading number, method of shipment, etc... 14 days prior to shipment.

C-331 PRODUCTION LOT TESTING (GOVERNMENT TESTING)

A. The Production Lot Samples shall be:

1. Selected at random by the cognizant government inspector. Such samples shall be submitted via the cognizant government inspector, all transportation charges prepaid by the contractor to:

NADEP Cherry Point
F.A.T. CONTROL CENTER
P.O.C. Betty Lupton, CODE : 6.3.674
NAS, Cherry Point, NC 28533

2. The samples shall be identified by contract number, lot number and be clearly marked as follows:

**PRODUCTION LOT TEST SAMPLES
NOT R.F.I. MATERIAL
DO NOT TAKE UP IN STOCK**

- B.** Such samples shall be delivered to the testing facility in sufficient time prior to the delivery date of the production articles to allow a 60 day period for testing by the laboratory and written notification by the contracting officer of the approval or disapproval of the samples. Within 90 days of the receipt of the samples, the testing facility shall notify the contracting officer of the results of the testing, together with a recommendation for approval or disapproval.
- C.** In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular production lot within 90 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.
- D.** If the contractor fails to deliver any production lot samples for testing within the time or times specified, or if the contracting officer disapproves any production lot samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of the contract, and this contract shall be subject to termination for default.
- E.** In order for a production lot to be acceptable, all samples representative of the lot must pass all of the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such an event, the government may, at its option and at no additional cost to the government, (I) terminate all or any portion of this contract for default, (II) require the manufacture of a new production lot, or a rework of the rejected production lot if the means and procedures proposed by the contractor for rework are acceptable to the government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked production lots in the same way as they did to the original production lots .

- F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of the failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the cost of reinspection, shipping, examination and retesting by the government, and the contractor and his sureties (if any) shall be liable for the amount of such costs.
- G. All transportation charges incurred in the submission and return of any production lot sample shall be borne by the contractor.
- H. Nothing contained in the foregoing provisions of this clause, and no action of the government in accordance herewith, shall in any way prejudice the right of the government under the clause of this contract entitled **Default**.

CONTRACT DATA REQUIREMENTS LIST <i>(1 Data Item)</i>					Form Approved OMB No. 0704-0188										
Public reporting burden for this collection of information is estimated to average 110 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed form to the Government Issuing Contracting Officer of the Contract/PR No. listed in Block E.															
A. CONTRACT LINE ITEM NO. 9G 1615-00-789-8779		B. EXHIBIT		C. CATEGORY: TOP _____ TM _____ OTHER _____											
D. SYSTEM/ITEM			E. CONTRACT/PR NO.		F. CONTRACTOR										
1. DATA ITEM NO. 3		2. TITLE OF DATA ITEM CERTIFICATION DATA / REPORTS			3. SUBTITLE										
4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T3			5. CONTRACT REFERENCE		6. REQUIRING OFFICE PCO										
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK 16*		14. DISTRIBUTION										
8. APP CODE A		11. AS OF DATE	13. DATE IF SUBSEQUENT SUBMISSION SEE BLOCK 16*		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th rowspan="2">a. ADDRESSEE</th> <th colspan="2">b. COPIES</th> </tr> <tr> <th>Draft</th> <th>Final</th> </tr> <tr> <td></td> <td></td> <td>Reg</td> <td>Repro</td> </tr> </table>		a. ADDRESSEE	b. COPIES		Draft	Final			Reg	Repro
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<p>PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 APPLY</p> <p>BLOCK#12- UPON SUBMITTAL OF FIRST ARTICLE SAMPLE (S) AND/OR PRODUCTION LOT SAMPLE.</p> <p>BLOCK #3- SEPERATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUB TITLES. CERTIFICATION REPORTS FOR PRIME PROCESS AND MATERIAL SPECIFICATIONS SHALL INCLUDE CERTIFICATION THAT ALL VENDORS PERFORMING THESE PROCESSES ARE SIKORSKY AIRCRAFT APPROVED SOURCES FOR SAID PROCESS.</p> <p>BLOCK #5 - CONTRACT REFERENCE: MATERIAL CERTIFICATION AND ANALYSIS DOCUMENTATION FOR: Valve, Damper Piston (78286) SS 4062-2 4130, per MIL-S-6758 cond. C.</p> <p>Certifications for the following: 1) Magnetic Particle Inspection Per ASTM E 1444 2) Heat Treat Per MIL-H-6875</p>					NADEP/CHRYPT										
					CODE: 6.3.674		*	1/0							
					PCO			1/0							
								2/0							
					G. PREPARED BY Timothy J. Mosser 0731.18			H. DATE 26 Oct 1998		I. APPROVED BY					
					J. DATE										

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE

CONTRACT DATA REQUIREMENTS LIST

(2 Data Items)

FORM APPROVED
OMB NO. 0704-0188

PUBLIC REPORTING BURDEN FOR THIS COLLECTION OF INFORMATION IS ESTIMATED TO AVERAGE 440 HOURS PER RESPONSE, INCLUDING THE TIME FOR REVIEWING INSTRUCTIONS, SEARCHING EXISTING DATA SOURCES, GATHERING AND MAINTAINING THE DATA NEEDED AND COMPLETING AND REVIEWING THE COLLECTION OF INFORMATION. SEND COMMENTS REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 22202-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDGET, PAPERWORK REDUCTION PROJECT (0704-0188), WASH. DC 20503. PLEASE DO NOT RETURN YOUR FORM TO EITHER OF THESE ADDRESSES. SEND COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PR NO. LISTED IN BLOCK E.

A. CONTRACT LINE ITEM NO. 9G 1615-00-789-8779		B. EXHIBIT		C. CATEGORY: TDP TM OTHER														
D.SYSTEM/ITEM			E. CONTRACT/ PR. NO.			F. CONTRACTOR												
1.DATA ITEM NO. 1		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT				3. SUBTITLE COMPLETE PROCESS OP SHEETS												
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T1			5. CONTRACT REFERENCE			6. REQUIRING OFFICE NADEP/Cherry Point												
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16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 SHALL APPLY * UPON SUBMISSION OF FIRST ARTICLE TESTING SAMPLE ** IF PROCESS OPERATION SHEETS CHANGE AFTER SUCCESSFUL COMPLETION OF F.A.T.					NADEP/CHRYPT													
					CODE:6.3.674													
					PCO													
					15. TOTAL													
					1. DATA ITEM NO. 2		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT				3. SUBTITLE COMPLETE INSP/ METHOD SHEETS							
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T2			5. CONTRACT REFERENCE			6. REQUIRING OFFICE NAVICP-PHIL												
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